

Work Order ID 64363

Thursday, December 02, 2010 1:51:11 PM

Page 1

Item ID: D3915-041

Accept

Revision ID:

Item Name: Light Lid Assembly, Long Basket

Start Date: 12/2/2010 Start Qty: 1.00

Required Date: 12/8/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: 10-12-02

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3915

C

100



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: 112860 0.00
Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D3915

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

10-12-06 (1A)

4 0 BE10/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 64363

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Item ID: D3915-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Light Lid Assembly, Long Basket

Start Date: 12/2/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

801207

70

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

ENSURE TO RINSE CAREFULLY ACID AND ALODINE

1 BR 10-12-7

140



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: 112860

0.00

Memo

0.00

1- weld (4) corners

lpl 10.12.07

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Start Date:	12/2/2010	Start Qty:	1.00			
Required Date:	12/8/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC Quality Control	Memo	0.00				1	0		BE10/12/07
155 	QC6- Inspect dimensions to drawing	0.00							
QC Quality Control	Memo	0.00							8/10/12/07
	inspect fit of lid with base								Going as a Replacement Lid
157 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00							1 BL 10-12-7
	1- realodine corners ***do not acid etch***								

W/O:		WORK ORDER CHANGES					
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Start Date: 12/2/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115951

Memo

0.00

1- touch up corner with alodine only
2- Plug holes prior to

1ST COAT: 7:20
START TIME: 7:20
OVEN TEMPERATURE: 320°
FINISH TIME: 7:50
***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

1 BR 10-12-8.

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

=> ul 10/12/08

Memo

0.00

1 Ø

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Assemble as per dwg

0.00

HandFinish

Memo

0.00

Hand Finishing

1- Install webbing as per dwg

2- Install placard and label as per dwg

190

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: GA 10 0.00

Packaging

Memo

0.00

Packaging

E/S 10/12/08 ①

④

E/S 10/12/08 ①

GA 10
W/O
64362

W/O:		WORK ORDER CHANGES					
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Required Date: 12/8/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/12/08
MF
10-12-08

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Picklist Print

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Page 1

Work Order ID: 64363

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket





Start Date: 12/2/2010

Required Date: 12/8/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1  Dart Logo label		Manufactured	No			180	Each	0.0000	1	1			
D2957  Mounting Plate		Manufactured	No			100	Each	11.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		11							
				58302		11							
D3915-1  Rib		Manufactured	No			100	Each	2.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				58379		2							
D4016-5  Hinge Half, Light Lid		Manufactured	No			100	Each	18.0000	3	3			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ENG		2							
				56075		2							
				ST116		10							
				58304		10							
				WA		6							
				63751		6							

③

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Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 12/2/2010

Required Date: 12/8/2010

Start Qty: 1.00

Required Qty: 1.00

D4019-3

 Rib

Manufactured No

100 Each

7.0000

3



3
 Cpl 10.12.06

Location

Loc Qty

Loc Code

WA

7

58386

1

59745

6

①
 ②

D4029-041

 Webbing (Long Basket)

Manufactured No

180 Each

5.0000

1



1
 Cpl 10.12.08

Location

Loc Qty

Loc Code

st503

5

56963

1

58109

4

1

D4035-045

 Lid Rib Assembly, Fwd (Light)

Manufactured No

100 Each

2.0000

1



1
 Cpl 10.12.06

Location

Loc Qty

Loc Code

WA

2

59733

2

①

D4035-047

 Lid Rib Assembly, Aft (Light)

Manufactured No

100 Each

2.0000

1



1
 Cpl 10.12.06

Location

Loc Qty

Loc Code

WA

2

59734

2

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 12/2/2010

Required Date: 12/8/2010

Start Qty: 1.00

Required Qty: 1.00

D4056-1

 Label Plate

Manufactured No

100 Each

11.0000

1

1



Pl 10-12-00

Location

Loc Qty

Loc Code

WA

11

58308

9

59750

2

①

MS20600-AD4W3

 Cherry Rivets

Purchased No

180 Each

1,439.000

34

34



ES 10/12/08

Location

Loc Qty

Loc Code

ST321

1439

107939

754

111636

685

34

NAS1149DN416J

 Washer

Purchased No

180 Each

468.0000

34

34



ES 10/12/08

Location

Loc Qty

Loc Code

ST

4

13910

4

ST275

68

114340

68

ST298

396

114348

52

114597

344

34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

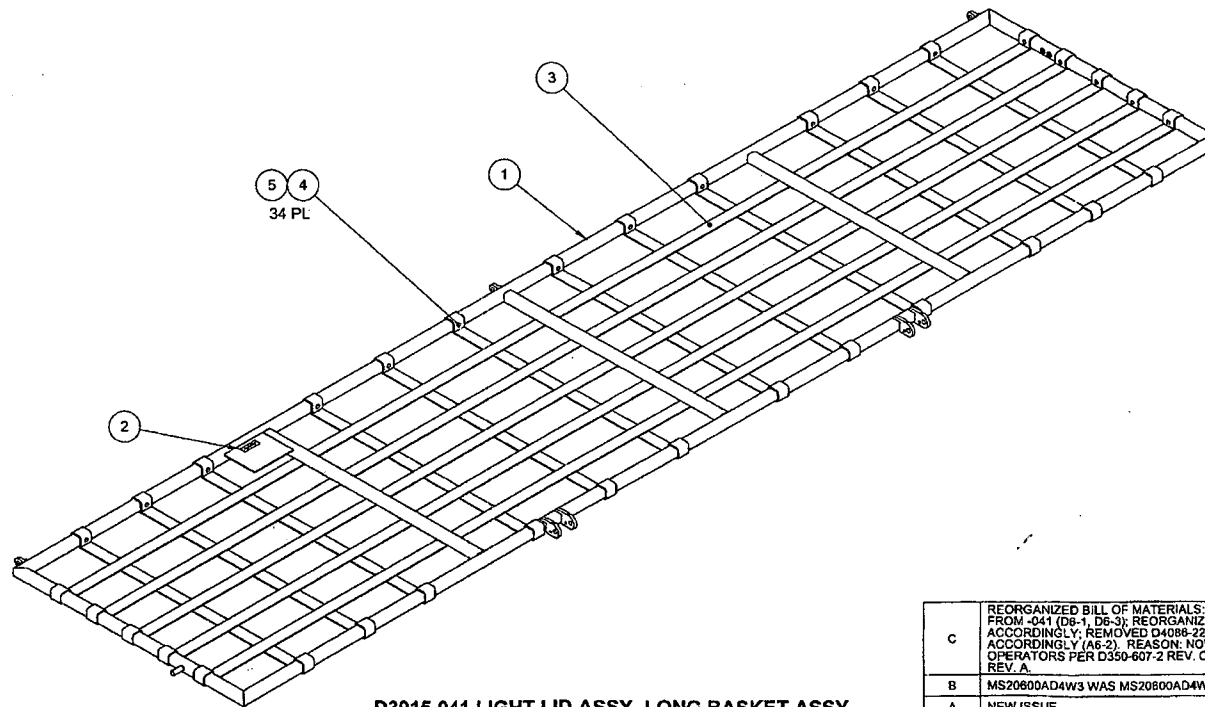
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ITEM	QTY	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	MS20600AD4W3	BLIND RIVET
5	34	NAS1149DN416J	WASHER



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

RELEASED
10-08-12
ECN 10-596

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: NONE
 7) WEIGHT: 6.91 lbs

C	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4088-220; UPDATED VIEW E ACCORDINGLY (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A	MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)	JPH	10.04.08
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3915	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

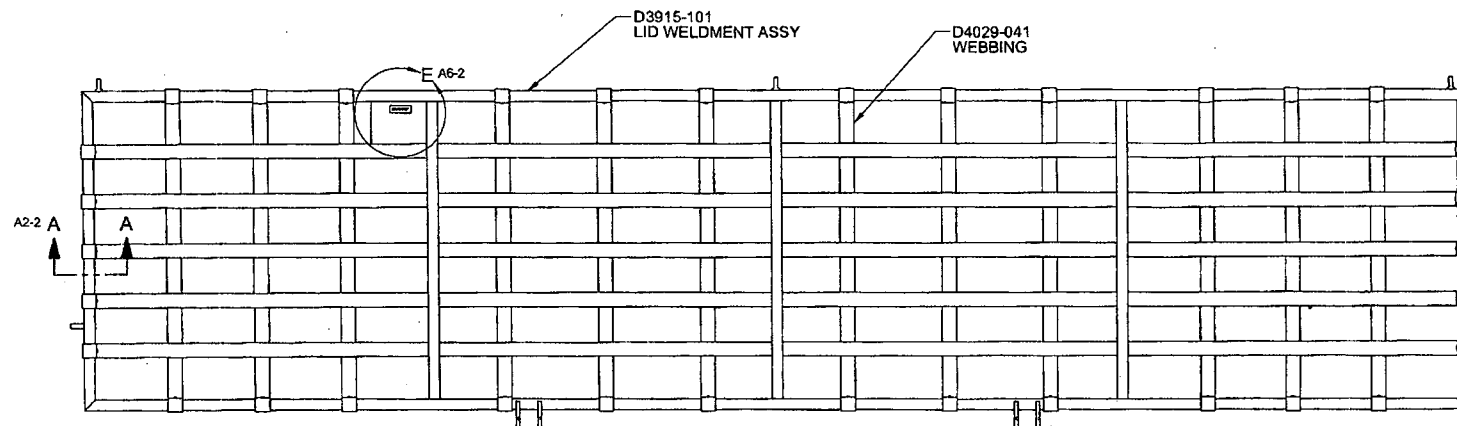
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

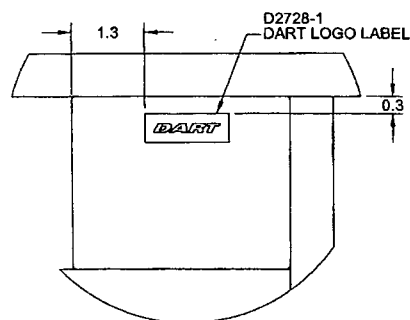
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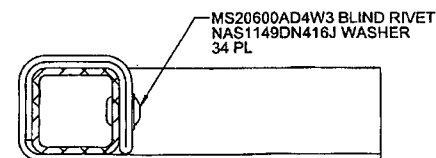
NOTE: Date & initial all entries



D3915-041 LIGHT LID ASSY, LONG BASKET



VIEW E D8-2



SECTION A-A C8-2

RELEASED
10.08.12

#64363

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	A	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Sc	DRAWING NO.	REV. C
MFG. APPR.	Sc	D3915	SHEET 2 OF 4
APPROVED	WJD	TITLE	SCALE
DE APPR.	WJD	LIGHT LID ASSY-LONG BASKET	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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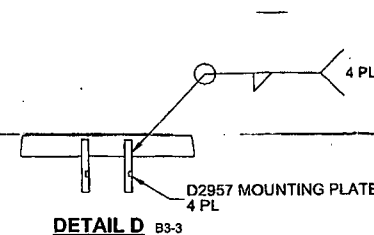
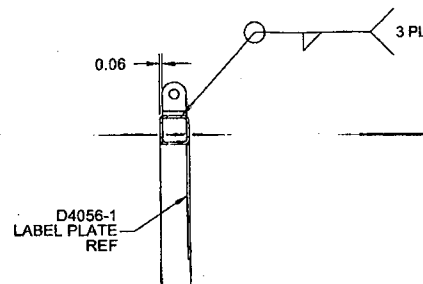
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

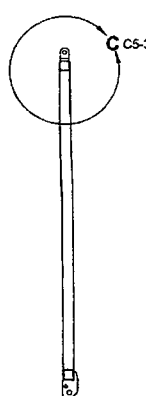
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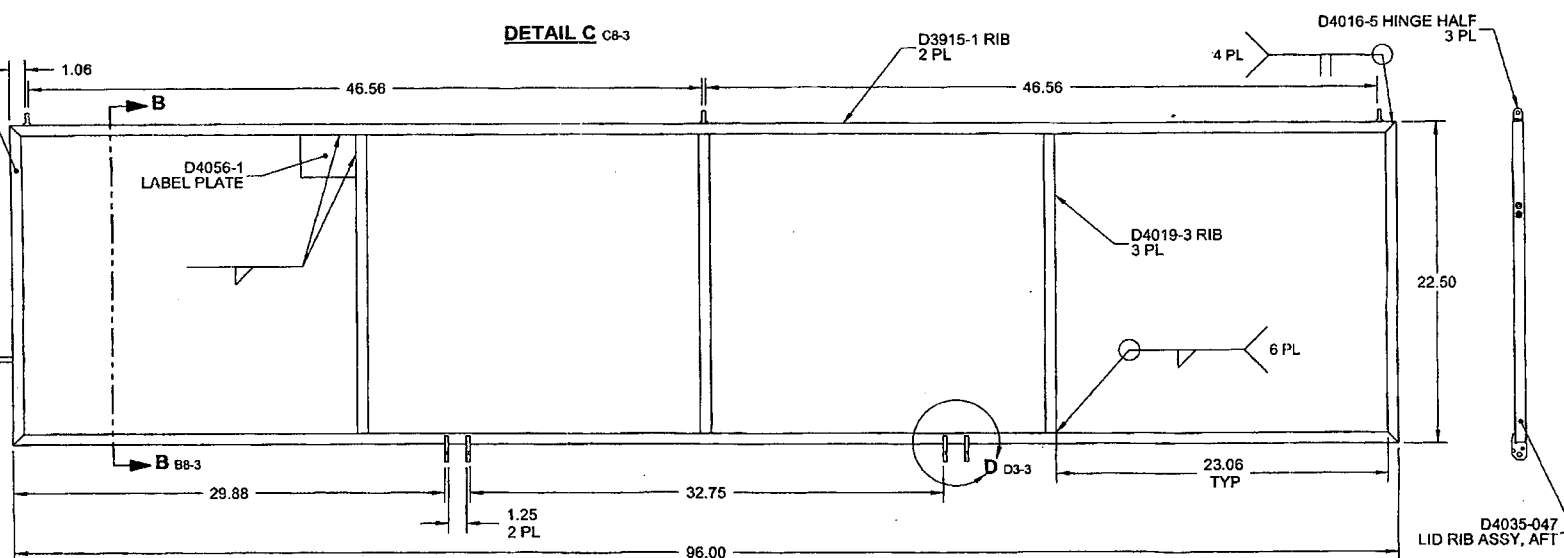
ITEM	QTY	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	2	D3915-1	RIB
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



D4035-045
LID RIB ASSY, FWD



SECTION B-B
B7-3



D3915-101 BASKET LID WELDMENT ASSY

RELEASED
10-08-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.81 lbs
- 8) WELD PER DART QSI 004

#64363

DESIGN	4.15	DART AEROSPACE LTD	
DRAWN	3.6	HAWKESBURY, ONTARIO, CANADA	
CHECKED	3.6	DRAWING NO.	REV. C
MFG. APPR.	3.6	D3915	SHEET 3 OF 4
APPROVED	3.6	TITLE	SCALE
DE APPR.	3.6	LIGHT LID ASSY-LONG BASKET	TNTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

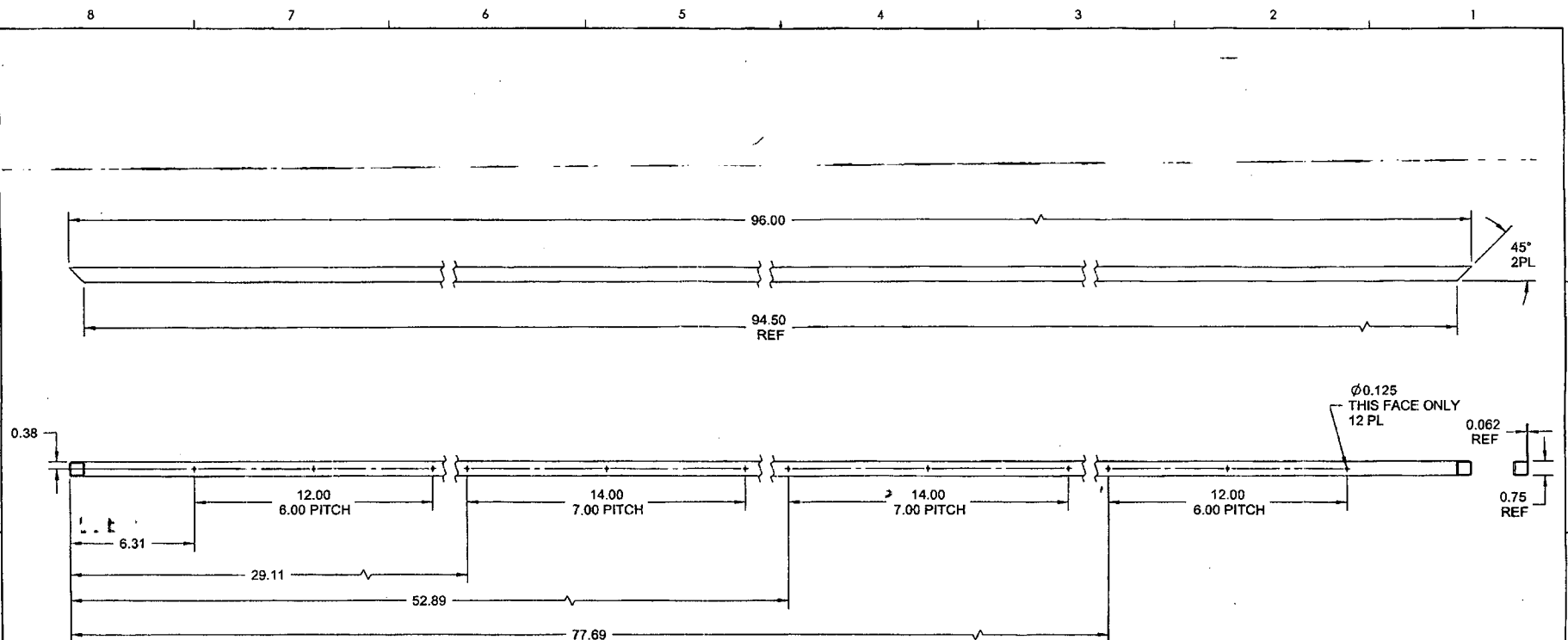
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3915-1 RIB

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.49 lbs

#64363

RELEASED
10.09.12 CP

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D3915	REV. C
CHECKED	SC	SHEET 4 OF 4	
MFG. APPR.	MP	SCALE	
APPROVED	MP	TITLE LIGHT LID ASSY-LONG BASKETNTS	
DE APPR.	MP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE RELEASED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries